



CEWELD CuNi30Fe

TYPE	Copper-Nickel alloyed Mig / Tig welding wire.								
APPLICATIONS	This Copper-Nickel weld metal is widely used for marine and desalination applications. Dissimilar-welding applications for this alloy are joints between Monel alloys or Nickel 200 and Copper-Nickel alloys. Often used for surfacing on steel by using Ceweld NiTi-3 as a barrier layer. Shipbuilding, seawater evaporation plants, tubes, pump building, offshore, desalting equipment and parts etc.								
PROPERTIES	Sound, pore free deposits on ferrous and non-ferrous base materials offering excellent resistance to corrosion in sea water.								
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.7: ERCuNi</td> </tr> <tr> <td>EN ISO</td> <td>24373: Cu 7158 / CuNi30Mn1FeTi</td> </tr> <tr> <td>W.Nr.</td> <td>2.0837</td> </tr> <tr> <td>F-nr</td> <td>34</td> </tr> </table>	AWS	A 5.7: ERCuNi	EN ISO	24373: Cu 7158 / CuNi30Mn1FeTi	W.Nr.	2.0837	F-nr	34
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SUITABLE FOR (Monel 67): Wrought and cast alloys of 70-30, 80-20 and 90-10 copper nickel alloys, Monel 450, (alloy 450), Nickel 200, CuNi10Fe, CuNi20Fe (2.0878), CuNi30Fe (2.0882), 2.0872 - CuNi 10 Fe 1 Mn (CuNi 10 Fe),

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

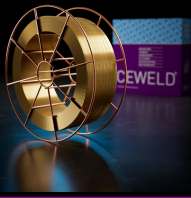
Si	Mn	P	Ti	Fe	Pb	Cu+Ag	Ni+Co	S
0.2	0.5	0.01	0.35	0.55	0.01	Rem.	30.5	0.01

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	200	420	36	200		115 HB

REDRYING Not required

GAS ACC. EN ISO 14175 I1, I3



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CUNI30FE 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663409522
D-100	1	8720663409539

CUNI30FE 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663409546

CUNI30FE 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,6	8720663409560
BS-300	15	8720663409553

CUNI30FE 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663409577

CUNI30FE 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663409638